Work Order ID 109740

November-27-13 12:57:30 PM

109740

Item ID: D212-725-1-245 **Accept** *N900040100* **Setup Start** *NS1*

Revision ID: **Stop** *NS2*

Item Name: Cam

Start Date: 11/27/13 **Start Qty:** 1.00 *1*

Required Date: 11/28/13 **Req'd Qty:** 1.00 *1*

Reference:

Cust Item ID:

Customer:

Run Start *NR1*

Stop *NR2*

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Draw Nbr	Revision Nbr
D212-725-1	~~G PRELIM~~ A

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
100		0.00							
100									
Bandsaw	**Memo**	0.00	CMK 13/11/28			1	0		
Jeaspa Bandsaw	Cut blanks 3.250" long								
110		0.00							
110									
HAAS 1	**Memo**	0.00	CMK 13/11/28			1	0		
HAAS CNC vertical machine #1	Machine as per folio FA844 and DWG Folio rev: AA Dwg Rev: A Deburr as per Dwg								

Item ID: D212-725-1-245 **Accept** *N900040100* **Setup Start** *NS1*
Revision ID: **Stop** *NS2*
Item Name: Cam

Start Date: 11/27/13 **Start Qty:** 1.00 *1*
Required Date: 11/28/13 **Req'd Qty:** 1.00 *1*
Reference:

Cust Item ID:
Customer:

Run Start *NR1*
Stop *NR2*

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____
QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120 *120* QC Quality Control	QC2- Inspect parts off machine FAI/FAIB **Memo**	0.00 0.00	AMR 13/11/28			1	Ø		
130 *130* Mill Conv Conventional Milling Machine	**Memo** Drill & tap as per Dwg	0.00 0.00	DP 13-11-30			1	Ø		
140 *140* QC Quality Control	QC2- Inspect parts off machine FAI/FAIB **Memo**	0.00 0.00	DP 13-11-30.			1	Ø		

Item ID: D212-725-1-245 **Accept** *N900040100* **Setup Start** *NS1*
Revision ID: **Stop** *NS2*
Item Name: Cam
Start Date: 11/27/13 **Start Qty:** 1.00 *1* **Cust Item ID:**
Required Date: 11/28/13 **Req'd Qty:** 1.00 *1* **Customer:**
Reference:

Run Start *NR1*
Stop *NR2*

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____
QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150 *150* QC Quality Control	QC8- Inspect parts - second check **Memo**	0.00 0.00	DAS 40 9-89 13/12/02			1	Ø		
160 *160* HandFinish Hand Finishing	Chemical Conversion Coat per QSI005 4.1 **Memo**	0.00 0.00				1	TG 13-12-3		
170 *170* QC Quality Control	QC3 Inspect Part Finish **Memo**	0.00 0.00	DAS 27 9-89 13/12/03			1			

Item ID: D212-725-1-245 **Accept** *N900040100* **Setup Start** *NS1*
Revision ID: **Stop** *NS2*
Item Name: Cam

Start Date: 11/27/13 **Start Qty:** 1.00 *1* **Cust Item ID:**
Required Date: 11/28/13 **Req'd Qty:** 1.00 *1* **Customer:**
Reference:

Run Start *NR1*
Stop *NR2*

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____
QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
180		0.00							FF
180						1			13-12-03
Small Fab	**Memo**	0.00							
Small Fab	Insert Helicoil as per Dwg								
190	QC5- Inspect part completeness to step on W/O	0.00		DAS 30 9-89					13/12/03
190						1			
QC	**Memo**	0.00							
Quality Control									
200	Identify as per dwg & Stock Location: Sylvie	0.00							
200						1			13-12-03
Packaging	**Memo**	0.00							
Packaging									

Item ID: D212-725-1-245 **Accept** *N900040100* **Setup Start** *NS1*
Revision ID: **Stop** *NS2*
Item Name: Cam

Start Date: 11/27/13 **Start Qty:** 1.00 *1*
Required Date: 11/28/13 **Req'd Qty:** 1.00 *1*
Reference:

Cust Item ID:
Customer:

Run Start *NR1*
Stop *NR2*

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____
QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
210	QC21- Final Inspection - Work Order Release	0.00					13/12/4		
210									
QC	**Memo**	0.00							
Quality Control									

pl 13-12-4

Picklist Print

November-27-13 12:57:29 PM

Work Order ID: 109740

Parent Item: D212-725-1-245 **Start Date:** 11/27/13 **Required Date:** 11/28/13

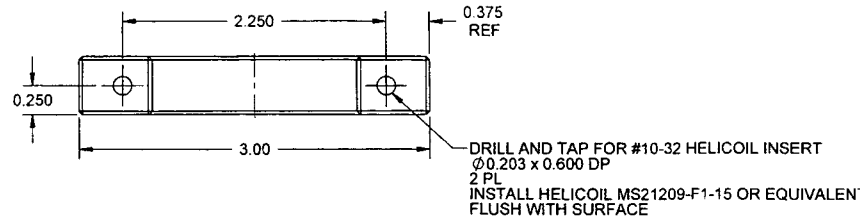
Parent Item Name: Cam **Start Qty:** 1.00 **Required Qty:** 1.00

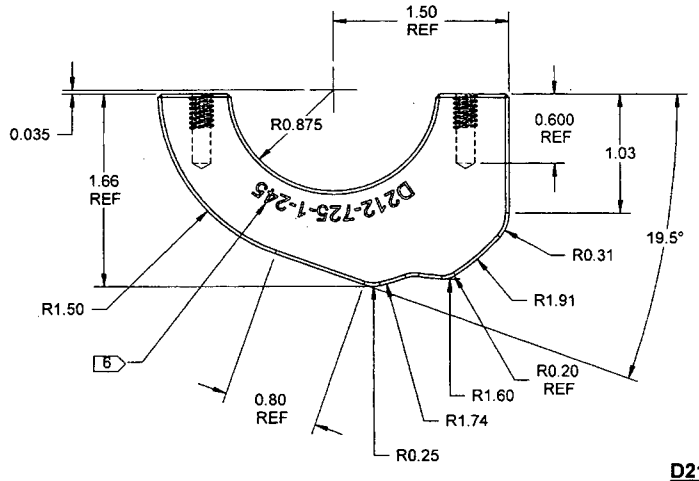
Comments: IPP RevA: New issue DD verified by:EC

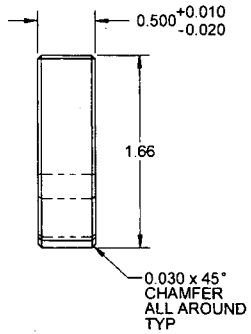
Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MS21209F1-15 HELI COIL		Purchased	No			160	Each	107.0000	2	2	DAS 32 9-89		
				Location		**Loc Qty**		**Loc Code**					
				ST319		107							
					121166	4							
					123935	10							
					m126741	93							
M6061T6B0.625X02.500 6061-T6 Bar .625 x 2.50		Purchased	No			100	f	44.1410	0.3	1			
				Location		**Loc Qty**		**Loc Code**					
				MAT		44.141							
					m125771	44.141							

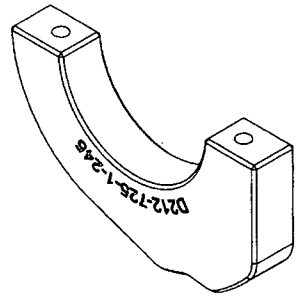
m126741

.30 mk 13/11/28









RELEASED
2011 -08- 25

D212-725-1-245 CAM BASE ASSEMBLY

M# 109240

NOTES:
1) MATERIAL: 6061-T6 (OR 6061-T651/T6510/T6511/T62) ALUMINUM BAR
PER AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116)
PER AMS-QQ-A-200/8 (OR AMS 4160)
REF. DART SPEC. M6061T6B
2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1 PRIOR TO ASSEMBLY
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: IDENTIFY PER QSI 044 6.3 AS SHOWN
7) WEIGHT: 0.14 lbs

DESIGN	RF	**DART AEROSPACE LTD**
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA
CHECKED		DRAWING NO. D4163 REV. A
MFG. APPR.		SHEET 2 OF 3
APPROVED		TITLE CAM ASSEMBLY SCALE NTS
DE APPR.		
DATE 11.02.24		

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DART AEROSPACE LTD	Work Order:	109740
Description: CAM BASE ASSEMBLY	Part Number:	D212-725-1-245
Inspection Dwg: D4163 Rev: A		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
.250	±.010					
2.250	±.005					
.375	±.010					
3.00	±.030	3.000	✓		Vern	ML-06
1.66	±.030	1.660	✓		"	
.600	±.010					
.500	±.010 ±.020	.497	✓		Vern	ML-06
.030X45°	±.010/±½°	.022X45°	✓		"	
.250	±.010	.250	✓		VERN	DR16
2.250	±.010	2.249	✓		VERN	DR16
.600 REF	±.030	.600	✓		VERN	DR16
.375 REF.	±.030	.371	✓		VERN.	DR16

Measured by:		Audited by:	DAS 40 9-89	Preliminary Approval:	
Date:	13/11/28 13/11/30.	Date:	13/12/02	Date:	

Rev	Date	Change	Revised by	Approved
E	10.04.14	Added preliminary approval	KJ	

10.04.15